

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011409**Date Inspected:** 09-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

ZPMC personnel installing inner and outer skin splice plates on PCMK south tower, lift 2, skin B, at the lift 2/lift 3 joint at the top of lift 2.

ZPMC personnel installing inner and outer skin splice plates on PCMK north tower, lift 2, skin A, at the lift 2/lift 3 joint at the top of lift 2.

SMAW welding of temporary attachment plates outside PCMK south tower, lift 2, skin E, at the skin D/E corner, at the top of 77M double diaphragm doubler plate. Welder was identified as 053469. ZPMC QC was identified as CWI Liu Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2112.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

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No welding work was being performed in Bay 11.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

FCAW welding of weld joint WSD1-SA255-1B/E-10 located inside PCMK west tower, lift 1, stiffener plate assemblies. Welder was identified as 040736. ZPMC QC was identified as CWI You Qi Guo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint WSD1-SA255-1F/H-8 located inside PCMK west tower, lift 1, stiffener plate assemblies. Welder was identified as 053486. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
